

Date: Wednesday, 03/06/2009 10:50:36 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : RADIUS BLOCK
<b>Job Number</b> : 48370	
<b>Estimate Number</b> : 12813	
<b>P.O. Number</b> :	<b>Part Number</b> : D36011
<b>This Issue</b> : 03/06/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3601 REV A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : // <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 44289	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 15/06/2009 <b>Qty:</b> 40 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>J.D. 09-06-03</u>	
<b>Comment</b> : Est Rev:A New Issue 07-03-28 JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M6061T6B0750X00125	6061-T6 Bar .750 x .125
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**Comment:** Qty.: 0.0962 f(s)/Unit Total : 3.8472 f(s)  
 6061-T6 Bar .75" x .125"

Material: 6061-T6 (QQ-A-250/11) or 5052-H34 (QQ-A-250/8) 1/8" X 3/4" BarBatch 104725 x 3.8472 f(s)

*JIP 09/06/07*

2.0	SHEAR	SHEAR
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**Comment:** SHEAR  
 Shear blanks 9.00" long +/- 0.030"  
 Note: 1 blank makes 8 pieces

*JIP 09/06/07*

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA682 Rev: AA & Dwg D3601 Rev: A

*J.L. 09/06/10*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

*J.L. 09/06/10*

5.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

*J.L. 09/06/10 (4)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 03/06/2009 10:50:36 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RADIUS BLOCK

Job Number: 48370

Part Number: D36011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



(45% Cont'd)

Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble

Deburr any rough edges after tumbling

MF 09/06/10

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(40)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BF 09-06-10

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-06-10 (40)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 118

SS 09/06/11 (40)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/11

Job Completion



MF 09-06-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

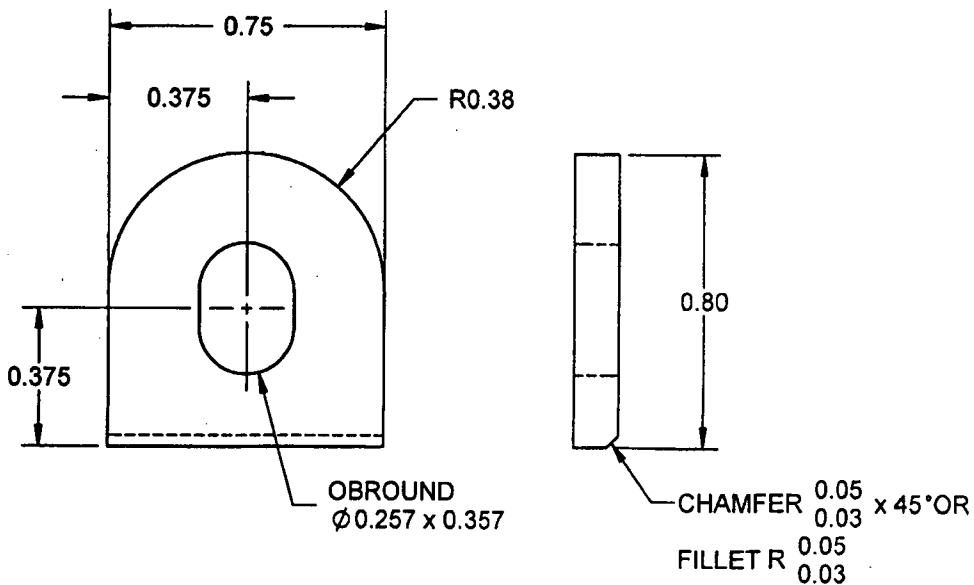
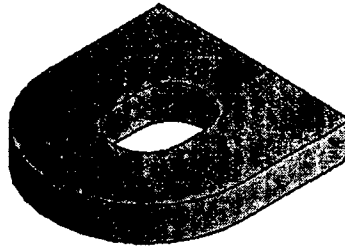


**DART**

DESIGN <i>CB</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CB</i>	APPROVED <i>CB</i>	DRAWING NO. D3601	REV. A SHEET 1 OF 1
DATE 07.02.13	TITLE RADIUS BLOCK		SCALE 2:1
REV A	DATE 07.02.13	DESCRIPTION NEW ISSUE	

RELEASED

07.03.08

**D3601-1 RADIUS BLOCK****NOTES:**

- 1) MATERIAL: ALUMINUM 5052-H32 SHEET, 0.125 THICK PER QQ-A-250/8 OR AMS 4016 (REF DART SPEC M5052H32S.125) OR ALUMINUM 6061-T6 SHEET, 0.125 THICK PER QQ-A-250/11 OR AMS 4025/4027 (REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3601-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.050 MAX

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WITHOUT NOTICE  
NO. 48370

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